

Work Order ID 63952

Monday, November 22, 2010 9:15:20 AM



Page 1

Item ID: D117-762-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 11/22/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/29/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *K*

Date: *10-11-22*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3582

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D117-762-041 CHG001

N/A *22*

120

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend I

Memo

0.00

CNC Delta 100 Bender

Bend tube as per program D3582 on CNC Bender and Dwg D3582. Folio 3,
use bending aid DT9632
2- cut fwd end of tube as per dwg

> DP

10-12-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Skidtubes

Skidtubes

Skidtubes

Memo

1-Cut Aft end using DT8185

2-Deburr ends

3-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE***

4-Locate DT 8973 & Drill Ground wire hole on top of Tube.

5-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill.

6-Drill pilot holes for wearplates using DT8974

7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.

8- open ground wear holes to 0.391" as per section B-B

9-Open Aft Cap holes using .209" drill.

10-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size.

1 0 BE 10/12/02

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Weld fwd cap D2964 per dwg D3582 and QSI 004

A/R AL ROD

Batch:

m111385/ m115778

2-Grind flush

1 0 BE 11/22/02

150

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

81012102

160

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

81012102

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10-12-6

JE (1) JE 10/12/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

0.00



Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-Open X-Bolt holes to finish size as per Dwg D3582, all sections

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube, prep. tube for welding.

4-Bond web as per Dwg D3582 & QSI 015

A/R 241 Sike Flex Batch: M116040

Exp Date: 11-9-30

5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B.

A/R AL ROD Batch: M111385

6-Grind welds flush

0.00

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

200



QC

Quality Control

[Handwritten signature]

10-12-7

BE 10/12/09

BE 10/12/09

8 10/12/13

[Handwritten mark]

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/12/13

QC

215

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Touch-up alodine as per QSI

2/11 10/12/03

1 8

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME 7:40
OVEN TEMPERATURE 300°
FINISH TIME 8:10

M15851

1 BL 10-12-14

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 11/22/2010 Start Qty: 1.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00		10112114		1	0		
Quality Control									
240	HandFinishing	0.00							
HandFinish	Memo	0.00		10112114		1	0		
Hand Finishing	Install Wearplate & Ground Wire inserts as per Dwg D3582.								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date:	11/29/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250  HandFinish	HandFinishing	0.00							
Hand Finishing	<p>Memo</p> <p>✓ 1-Inspect for Foreign objects</p> <p>✓ 2-Install Aft cap as per Dwg D3582, Detail "C" A/R 241 Sika Flex Batch: <u>M115114</u> Exp Date: <u>11/01</u></p> <p>✓ 3-Install Wearplates as per Dwg D3582, Note: Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582 *****Do not install bolts where indicated on Dwg(Note #6)***** ✓ A/R 241 Sika Flex Batch: <u>M115114</u> Exp Date: <u>11/01</u></p> <p>✓ 4-assemble o'ring as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M114189</u></p> <p>✓ 5- Wing Walk as per Dwg D3582 and QSI 005 4.4 <u>M115790</u></p>	0.00							
260  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	<p>Memo</p> <p>8/10/15</p>	0.00							

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D117-762-041

Location: _____

PPP Rev: _____

PPP 63950

280

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/12/23

10/12/23

10-12-23

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 63952

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube



Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A ☐ 07.06.11 ☐ New Issue ☐ EC

IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2962-150

Manufactured

No

Each

95.0000

1

1



3.540 Outer Tube, Extrud

Location

Loc Qty

Loc Code

HALL

95

28672

22

59934

73

1 BE 10/12/01

D2964

Manufactured

No

140

Each

16.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG

16

14101

16

1 BE 10/12/02

D2971

Manufactured

No

190

Each

24.0000

1

1



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

24

44445

24

1 BE 10/12/03

D3584-1

Manufactured

No

190

Each

0.0000

1

1



Web

B64097

①

DP 10-12-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 63952



Parent Item: D117-762-041



Parent Item Name: Replacement Skidtube

Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

D2973 Manufactured No

190 Each

156.0000

2

2



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

156

14636

156

190 Each

24.0000

1

1

D3662-3

Manufactured No



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

24

44456

24

190 Each

10.0000

3

3

D3662-1

Manufactured No



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

10

55328

10

240 Each

2,077.000

36

36

ALS4-1032-130

Purchased

No



Insert

Location

Loc Qty

Loc Code

PKG11

804

114723

804

ST281

1000

116049

1000

ST282

234

110511

10

115911

224

ST381

39

114654

39

x36

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-428-165

Purchased

No

240

Each

101.0000

2

2



HL 10/12/14

Inserts

Location

Loc Qty

Loc Code

FP

5

6989

5

ST282

96

114172

96

X2

D2965

Manufactured

No

250

Each

39.0000

1

1



HL 10/12/14

Cap, 105 Skidtube

Location

Loc Qty

Loc Code

FP4

39

52057

39

X1

D3508-3

Manufactured

No

250

Each

10.0000

1

1



HL 10/12/14

Wearplate

Location

Loc Qty

Loc Code

FP

1

38527

1

FP21

9

62882

9

X1

D3508-9

Manufactured

No

250

Each

7.0000

1

1



HL 10/12/14

Wearplate

Location

Loc Qty

Loc Code

FP16

6

62887

6

FP21

1

54580

1

X1

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Start Date: 11/22/2010



Required Date: 11/29/2010

Start Qty: 1.00



Required Qty: 1.00

D3558-3 Manufactured No 250 Each 10.0000 1 1
  HL 10/12/14
 Gasket



Location	Loc Qty	Loc Code
FP	10	
42253	1	
<u>55468</u>	9	<u>VI</u>

D3558-9 Manufactured No 250 Each 15.0000 1 1
  HL 10/12/14
 Gasket

Location	Loc Qty	Loc Code
FP	15	
50928	1	<u>VI</u>
55469	14	

D3558-11 Manufactured No 250 Each 12.0000 1 1
  HL 10/12/14
 Gasket

Location	Loc Qty	Loc Code
FP	12	
<u>62885</u>	12	<u>VI</u>

D3558-13 Manufactured No 250 Each 32.0000 1 1
  HL 10/12/14
 Gasket

Location	Loc Qty	Loc Code
FP	32	
<u>59558</u>	32	<u>VI</u>

W/O:		WORK ORDER CHANGES					
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Start Date: 11/22/2010

Required Date: 11/29/2010



Start Qty: 1.00

Required Qty: 1.00

D3508-11	Manufactured	No	250	Each	9.0000	1	1
							<u>10/12/14</u>
Wearplate							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP16	9	
<u>54644</u>	9	<u>X1</u>

D3508-13	Manufactured	No	250	Each	14.0000	1	1
							<u>10/12/14</u>
Wearplate							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP16	14	
<u>63248</u>	14	<u>X1</u>

D3492-051	Manufactured	No	250	Each	48.0000	2	2
							<u>10/12/14</u>
Plug Assembly							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP013	48	
44633	2	
<u>55622</u>	46	<u>X2</u>

D3492-049	Manufactured	No	250	Each	23.0000	2	2
							<u>10/12/14</u>
Plug Assembly							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP011	23	
<u>55621</u>	23	<u>X2</u>

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 6

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Work Order ID: 63952



Parent Item: D117-762-041



Parent Item Name: Replacement Skidtube

Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

D3492-053 Manufactured No

250 Each 23.0000 6 6



10/12/14

Plug Assembly

Location Loc Qty Loc Code

FP 1

54641 1

X1

FP013 22

62886 22

X5

AN960JD10L NAS1149D0332J Purchased No

250 Each 0.0000 2 2



X2 10/12/14

Washer

AN3C4A Purchased No

250 Each 2,115.000 28 28



10/12/14

BOLT

Location Loc Qty Loc Code

ST303 3

115438 3

ST350 2112

115300 42

115589 70

115936 1000

116075 1000

Y28

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

Monday, November 22, 2010 9:15:25 AM

Work Order ID: 63952



Parent Item: D117-762-041



Parent Item Name: Replacement Skidtube

Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No

250 Each

858.0000

2

2



10/12/14

Bolt

Location

Loc Qty

Loc Code

ST350

848

114330

11

115015

13

115371

100

115422

100

115594

282

115835

342

ST351

10

113121

10

XZ

AN960JD416L NAS1149D0416J Purchased

No

250

Each

186.0000

2

2



10/12/14

Washer

Location

Loc Qty

Loc Code

ST346

186

106785

2

110153

184

XZ

AN960C10L NAS1149C0332 Purchased

No

250

Each

25.0000

28

28



10/12/14

washer

Location

Loc Qty

Loc Code

ST245

25

107534

25

M115832

XZ

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

Monday, November 22, 2010 9:15:25 AM

Work Order ID: 63952

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

AN4-4A	Purchased	No	250	Each	176.0000	2	2
							<u>HL 10/12/14</u>
Bolt							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST356	175	
-------	-----	--

<u>114615</u>	175	<u>XZ</u>
---------------	-----	-----------

ST361	1	
-------	---	--

<u>111295</u>	1	
---------------	---	--

NAS1611-012	Purchased	No	250	Each	92.0000	6	6
							<u>HL 10/12/14</u>
O-RING							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	92	
----	----	--

<u>113845</u>	92	<u>X6</u>
---------------	----	-----------

NAS1611-015	Purchased	No	250	Each	98.0000	2	2
							<u>HL 10/12/14</u>
O-RING							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	98	
----	----	--

<u>107178</u>	3	
---------------	---	--

<u>115101</u>	16	<u>YZ</u>
---------------	----	-----------

<u>116081</u>	79	
---------------	----	--

NAS1611-016	Purchased	No	250	Each	103.0000	2	2
							<u>HL 10/12/14</u>
O-RING							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	103	
----	-----	--

<u>107178</u>	3	<u>YZ</u>
---------------	---	-----------

<u>112492</u>	50	
---------------	----	--

<u>113524</u>	50	
---------------	----	--

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

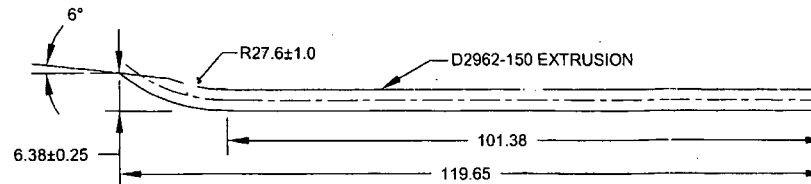
NOTE: Date & initial all entries

PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

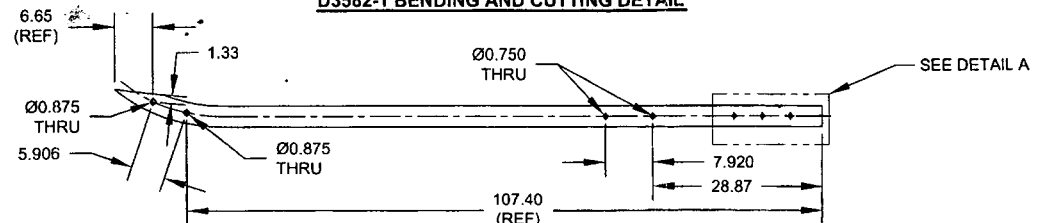
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AEIS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

GENERAL NOTES:

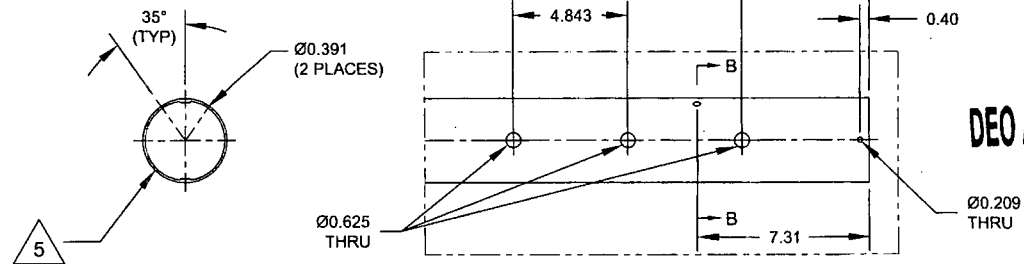
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- USE DART DRILL TEMPLATE DT8500 TO LOCATE AND DRILL Ø0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AEIS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- FINISH:
 - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
 - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 - ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4



D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 1:5

DETAIL A
SCALE 1:5

RELEASED
07.11.22

SHOP COPY
FOR REVIEW
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 63952

REV.	DESCRIPTION	PH	DATE
A	NEW ISSUE		07.06.08
DESIGN	PH		
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.06.08		

DART AEROSPACE USA, INC
PORT HADLOCK, WA
DRAWING NO. D3582
REV. A
SHEET 1 OF 2
TITLE BK 117 SKIDTUBE ASSEMBLY
SCALE 1:20
COPYRIGHT © 2007 BY DART AEROSPACE USA, INC
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phon 22

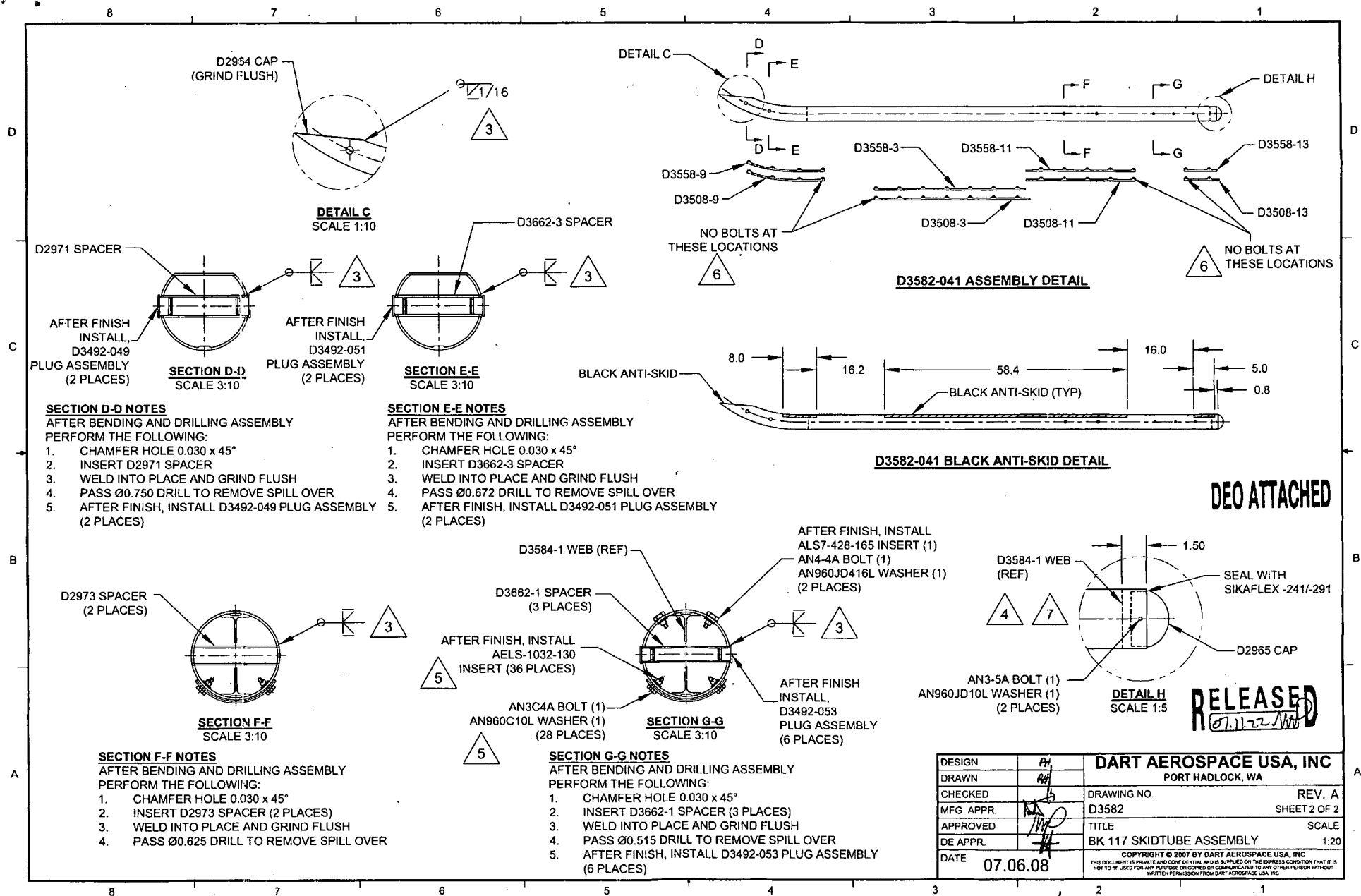
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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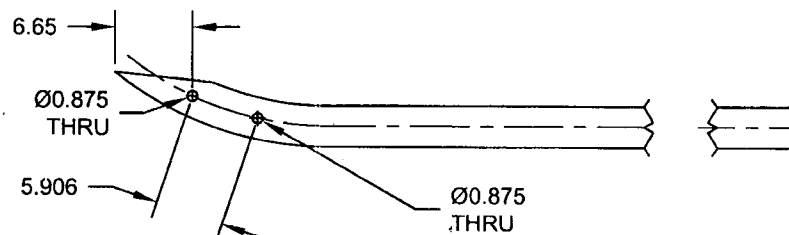
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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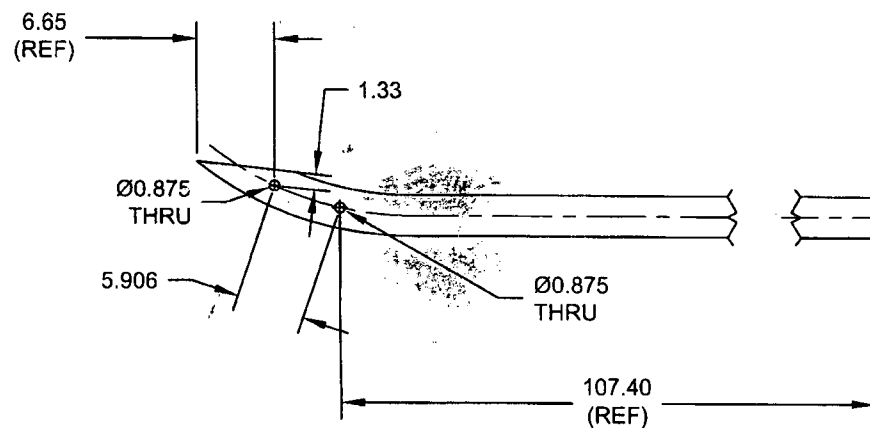
DRAWING NO. D3582	TITLE BK 117 SKIDTUBE ASSEMBLY	REV. A	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3582-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>PH</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.04.06	DATE 04.04.06	DATE 09.04.06	DATE 09/04/06		DATE 09.04.06		

FOR EASE OF MANUFACTURE AND TO ENSURE THE FIT OF BRISTOL WIRESTRIKE SKID GEAR DEFLECTOR:
UPDATE DIMENSIONING OF 2 FWD HOLES ON SHEET 1 AS SHOWN

IS:



WAS:



W/0 63952
RELEASED
09/04/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 220

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 54161
Part number: D17-762-041
Description: 17 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P.D. Date of Test Coupon 09.12.10

Welder Barday Elliott Date of Test Coupon 09/12/10

The above named individual is qualified in accordance with AWS D17.1.2001 to weld